

5/45

DART AEROSPACE LTD	Work Order:	24669
Description: Extrusion	Part Number:	D2500-1-190
Drawing: D2500 Rev. F1	Qty:	80

Step	Location	Procedure	By	Date	qty
1	DC	Issue Traveller	XJ	05/10/26	
2	PG	Issue P/O: <u>2008873</u> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long g) Bon L Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	AL	07/01/27	80
3	RG	Inspect for transit damage <b>Ensure certification are attached</b>	CL	05/11/15	77
4	QC6	Inspect dimensions per Dwg D2500 Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester	Z	06-04-04	77
5	ST	Identify & stock	Z	06-04-04	77
6	AC	Cost / part	Z	06-05-04	77
7	DC	Close W/O Inspect level 21	Z	06/04/05	77

Rev	Date	Change	Revised By	Approved
E	01.03.29	Changed part number to -190	EC	
F	01.10.29	Revised Step 2	SM	
G	02.09.05	Added DSK 066	KJ RF	C

RELEASED  
02/09/17 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 26/04/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DMS</i>	DRAWN BY <i>DMS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>KE</i>	APPROVED <i>DMS</i>	DRAWING NO. D2500 REV. F SHEET 1 OF 2
DATE 97:09:29	TITLE EXTRUSION SCALE NTS	

**RELEASED**  
97/10/06 DS

A	96:03:19	NEW ISSUE
B	96:03:24	CHANGE INTERNAL WEB
C	96:04:26	ADD D2500-3 WEB
D	96:10:07	ADD MATERIAL PROPERTIES
E	96:10:24	CHANGE MATERIAL TEMPER
F	97:09:29	CHANGE MAT. TO 6061-T6
F1	01.04.17	ADD NOTES 445 #4P

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)  
 D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # 897105 → PREFERRED  
 b) CARADON MIDCAST DIE # PAH-2B030  
 c) CARADON MTL DIE # MH-18868

5. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)  
 D2500-3 EXTRUSION MANUFACTURED FROM CARADON INDALEX DIE # MS-18867

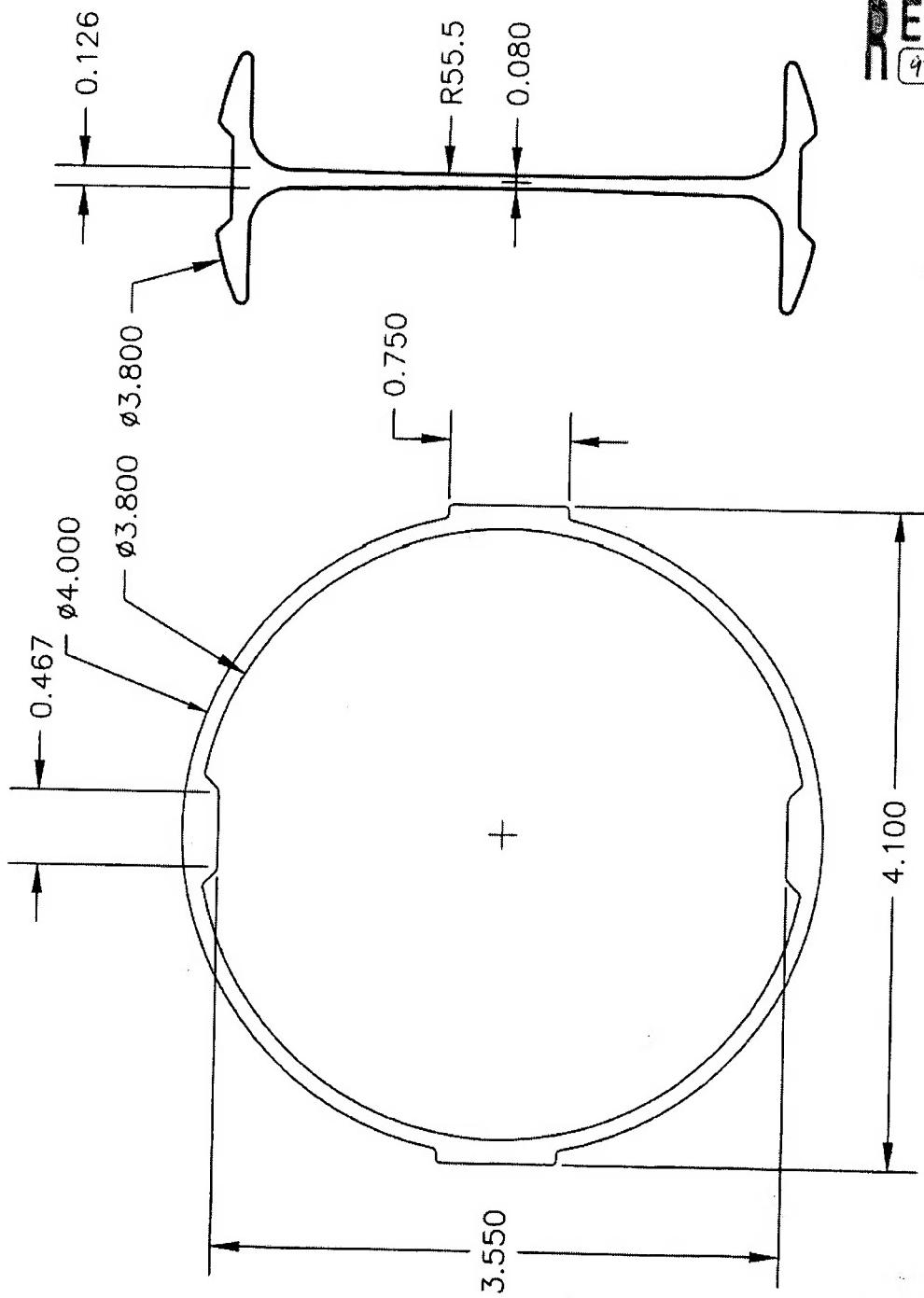
UNCONT  
SUBJECT TO  
WITHOUT

WORK OR.  
NO. 24669

**DART**

DCOPY ISSUE  
DUE

DESIGN <i>MJY</i>	DRAWN BY <i>MJY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>RE</i>	APPROVED <i>MJY</i>	DRAWING NO. D2500	REV. F SHEET 2 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE 1:1



## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyOct 25, 2005  
04:04 pm

Work Order No : 0024669  
 Project Name : D2500-1-190  
 Project For : WK545  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2500-1-190  
 Description : Ext'n - 'I' Beam Tube 4"  
 Manufactured : Yes  
 Amount Req'd : 80  
 Amount Done : 0  
 Start Date : 10-25-05  
 Est Finish Date : 11-08-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00



# CERTIFICATE OF COMPLIANCE

## BON L CANADA INC

1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8

Print Date	Cert. No.	Sales Order	Page
11/13/05	130483	75470	1
Print Date	Print No.	Lot	Date
2008873	00284675	75470010	11/13/05

Ship To	Ship To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7
Item No.	Part No.	Item Description
1.000	DAA-897105-2	190" Mill 6061 T6 ✓
Gross Weight	2165 LBS	
Net Wt.	2,094 LB	77 PC      1219 FT      4 PKG
Specification	Spec Desc	
AMS-QQ-A-200/8 & ASTM B221-00		

### Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HR-E
1	323.6 / 47.0	294.4 / 42.7	8.6	.0	94
2	315.3 / 45.8	288.3 / 41.8	8.8	.0	94

### Chemical Limits:

SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.400	.000	.150	.000	.800	.040	.000	.000 EA: .050
MAX:	.800	.700	.400	.150	1.200	.350	.250	.150 TOT: .150

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada